



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBW6205G13831-3G

Job Sheet 177004



004264

Part No: RBW6205G13831-3G

Job Qty: 1 ea

Part Name: AW139 Swashplate Box 2



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 5/4/18

Job Tracking No:

Due Date: 7/6/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBW6205G13831-3G REV 2 IPP REV A 18.02.15 NEW ISSUE FK VERIFY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		7/6/18	0.00	0.00	Start Up Small Fab-4		ML
110	Small Fab	1 pcs		7/6/18	0.00	1.00	Small Fab-4		ML
120	QC	1 pcs		7/6/18	0.00	0.00	QC5		FB
130	Packaging	1 pcs		7/6/18	0.00	0.00	Packaging3-1		MLDAS
140	QC21-FG	1 Ea		7/6/18	0.00	0.00	QC21	JUL 16 2018	53

Part Op 110 - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican case
Descriptions: APP-1600-E 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue placard
RBW6205G13831-3G-9 to RBW6205G13831-3G-7 foam as per DWG. 6-Glue foam to case and pack case as per DWG.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
97524A032	Sealing Blind Rivet	4 Ea (4 ea)	90-Start up Operation	5066776
3777T12	Spring Catch	2 Ea (2 ea)	110-Small Fab	50669403
APP-1600-E	Case	1 Ea (1 ea)	110-Small Fab	5077875
RB41011	Dart Tooling Placard, Aluminum	1 Ea (1 ea)	110-Small Fab	5071040
RBW6205G12731-3G	Upper Plate Assembly	1 Ea (1 ea)	110-Small Fab	5079012
RBW6205G13151-3G	Lower Plate	1 Ea (1 ea)	110-Small Fab	5067146
RBW6205G13231-3G	Arm Assembly	3 Ea (3 ea)	110-Small Fab	5078998
RBW6205G13531-3G	Screw Assembly	1 Ea (1 ea)	110-Small Fab	5065512
RBW6205G13831-3G-1	Shelf Backing	1 Ea (1 ea)	110-Small Fab	5077831
RBW6205G13831-3G-11	Dynamometer	1 pcs (1 ea)	110-Small Fab	6079915
RBW6205G13831-3G-3	Shelf	1 Ea (1 ea)	110-Small Fab	5077833
RBW6205G13831-3G-5	Bottom Foam use in case APP-1600-E	1 Ea (1 ea)	110-Small Fab	5077815
RBW6205G13831-3G-7	Lid Foam use in case APP-1600-E	1 Ea (1 ea)	110-Small Fab	5077819
RBW6205G13831-3G-9	Location Placard	1 Ea (1 ea)	110-Small Fab	5090088

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	97524A032	4	643	0
110-Small Fab	3777T12	2	4	0
	APP-1600-E	1	2	0
	RB41011	1	841	0
	RBW6205G12731-3G	1	2	0
	RBW6205G13151-3G	1	6	0

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date : _____ _____ _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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			MRB (QSI042) Approval																		
			Completed By																		
			Lead hand / Supervisor Approval Verification																		
			QC / QA Coordinator Approval																		
Container No: S090013 Part: FBW6205G13831-3G Job No: 177004 Serial No/Batch: S090013 Revision: 2 Inspector: Exp Date: Instructions: DART AEROSPACE 1270 Aberdeen Street Hamlet, NY 13346 TEL: 315 692-5200 Email: sales@dartaero.com www.dartaero.com Date: 07/09/18																					
Re Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ OTHER : ☐			Broken/Damage/Detect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐														

RBW6205G13231-3G	3	6	0
RBW6205G13531-3G	1	2	0
RBW6205G13831-3G-1	1	3	0
RBW6205G13831-3G-11	1	2	0
RBW6205G13831-3G-3	1	3	0
RBW6205G13831-3G-5	1	2	0
RBW6205G13831-3G-7	1	2	0
RBW6205G13831-3G-9	1	0	0

Part Specifications

Specifications could not be found.

Plex 7/6/18 10:42 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

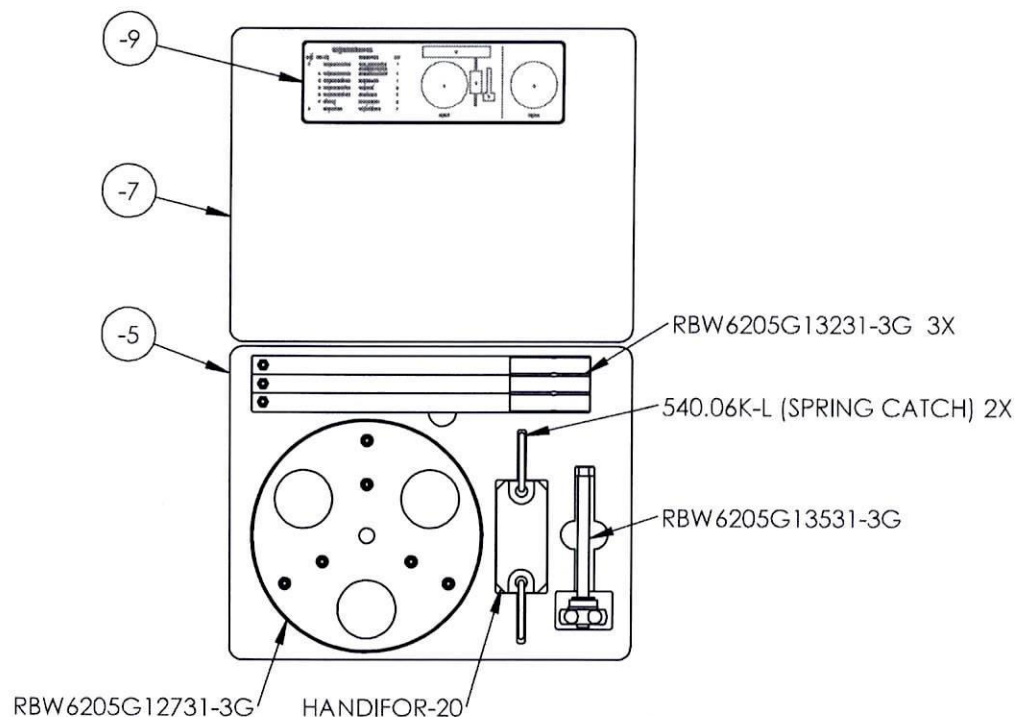
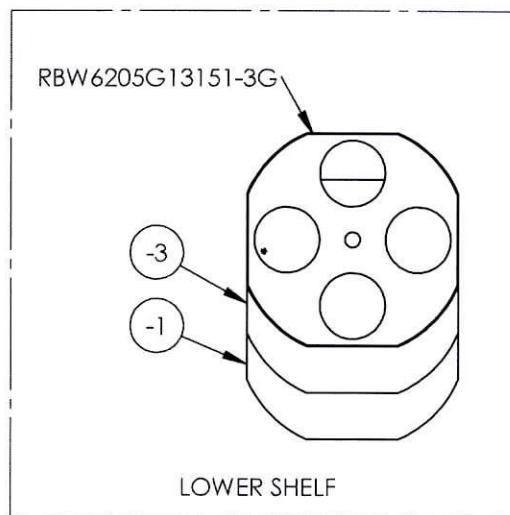
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Description Work Order Deviation				Disposition				Completed By																	
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										QC / QA Coordinator Approval															
Root Cause		FAULT CATEGORY																							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐																				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐																				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐																				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____																							
Misidentified ☐	Past Due ☐																								

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REVISIONS						
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED	
1		-1 & -3 ADDED NOTE. -5 CH'D OVERALL DIMENSIONS TO FIT CASE TIGHTER. -7 CH'D OVERALL DIMENSIONS TO FIT CASE TIGHTER. CH'D CUTOUT TO RECESSED POCKET ADDED CUTOUT ON BOTTOM FOR CASE PIN CLEARANCES AND MATERIAL FROM C200 FLAT TO 1780 FLAT BLACK.	6/29/2011	RJC	RW	
2	15-0151	-5 CH'D CUTOUT SIZE AND DEPTH FOR -11 & -13. CH'D DIM WAS ∇ 1.00 IS ∇ 1.60 FOR RBW6205G13231-3G. -7 CH'D FOAM WAS 1780 FLAT, BLACK IS Y20 BLACK. CH'D CUTOUT DEPTH FOR PLACARD WAS .063 IS .13. -9 REMOVED TEXT "CONTENT LIST". CH'D DESCRIPTION WAS PLACARD IS LOCATION PLACARD.	7/8/2015	RJC	JAG	



ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
				1	UPPER PLATE ASSEMBLY		RBW6205G12731-3G	1
				1	LOWER PLATE		RBW6205G13151-3G	1
				3	ARM ASSEMBLY		RBW6205G13231-3G	1
				1	SCREW ASSEMBLY		RBW6205G13531-3G	1
		B/O	-1	1	SHELF BACKING	COROPLAST	BLACK, 6mm Ø12-7/16 I.R. SPECIALTY	2
		B/O	-3	1	SHELF	Y20 BLACK	Ø12-7/16 X 13/16	3
		B/O	-5	1	BOTTOM FOAM	Y20 BLACK	6-1/8 X 16-3/4 X 21-3/4 I.R. SPECIALTY	4
		B/O	-7	1	UD FOAM	Y20 BLACK	1-3/4 X 16-3/8 X 21-5/16 I.R. SPECIALTY	5
			-9	1	LOCATION PLACARD	PLASTIC		6
		B/O	-11	1	DYNAMOMETER		HANDIFOR-20	1
		B/O	-13	2	SPRING CATCH	S.S.	Ø5/16 CARABINER STYLE (MCMASTER-CARR #3777T12)	1
		B/O	-15	1	CASE	PLASTIC, BLACK	8 X 17 X 22 PELICAN #APP-1600-E	N/S
		B/O	-17	1	DART PLACARD	ALUMINUM	#RB41011	N/S

NOTE:
PART OF KIT RBW6205G11231-3G.

		TITLE	
		AW139 SWASHPLATE KIT	
DWG NO.		REV	
RBW6205G13831-3G		2	
MATERIAL		DRAWN BY: CLOUGH	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		APPROVED <i>D West</i>	
.XXX ± .005 FRACTIONS ± 1/8		HEAT TREAT FINISH	
.XX ± .01 ANGLES ± 5°		SPEC	
.X ± .1		USED ON MODEL	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R		AW139	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING			
SCALE	DATE	SHEET 1 OF 6	
1:10	1/31/2011		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
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Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					